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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	21669
<b>Description:</b> Fitting	<b>Part Number:</b>	D3316-2
<b>Dwg:</b> D3316 Rev. A	<b>Qty:</b>	21
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	04.10.13	21
2	MV	Cut blank: (1.500" x 2.000") x 2.2" long Material: 17-4 PH SS Bar per AMS 5604/5643 (M17-4-B2.000X01.500) <b>Identify for D3316-2</b> Batch: 114579	SL	04/10/13	21
3	MV	Machine as per Folio FA467 and Dwg D3316 <b>Identify as D3316-2</b>	EE	04.10.18	1
4	QC2	Inspect parts as they come off the CNC machine	EE	04.10.18	1
5	QC8	Second check	EO	04/10/26	1
6	MV	Deburr	EE	04.10.26	1
7	QC5	Inspect work to Step 6	JLM	04.10.26	1
8	ST	Identify with part number & batch number using permanent fine point marker and Stock	EE	04.10.26	1
9	AC	Cost / part: 477.80	S4C	04.10.27	1
10	DC	Close W/O 477.80 Inspect Level 21	KJ	04.10.27	1

Rev	Date	Change	Revised By	Approved
A	04.10.04	New issue	KJ/JLM	

RELEASED  
04/10/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	21669
<b>Description: Fitting</b>		<b>Part Number:</b>	D3316-2
<b>Inspection Dwg: D3316 Rev: A</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.163	+/-0.010	0.156	✓			
R0.125	+/-0.010	R.125	✓			
2.060	+/-0.010	2.064	✓			
1.250	+/-0.005	1.252	✓			
Ø0.313	+0.005/-0.000	Ø0.314	✓			SLOT HOLES CP 04.10.26
R0.330	+/-0.030	R.312	✓			
0.080	+/-0.010	0.082	✓			
0.260	+/-0.010	0.251	✓			
Ø0.690	+0.005/-0.000	Ø.690	✓			
0.020	+/-0.010	0.016	✓			
1.000	+/-0.010	1.005	✓			
0.500	+/-0.010	0.502	✓			
R0.375	+/-0.010	R.375	✓			
Ø0.257	+0.005/-0.000	Ø.258	✓			
R0.13	+/-0.030	R.125	✓			
0.100	+/-0.010	0.108	✓			
1.080	+/-0.010	1.078	✓			
1.455	+/-0.010	1.454	✓			

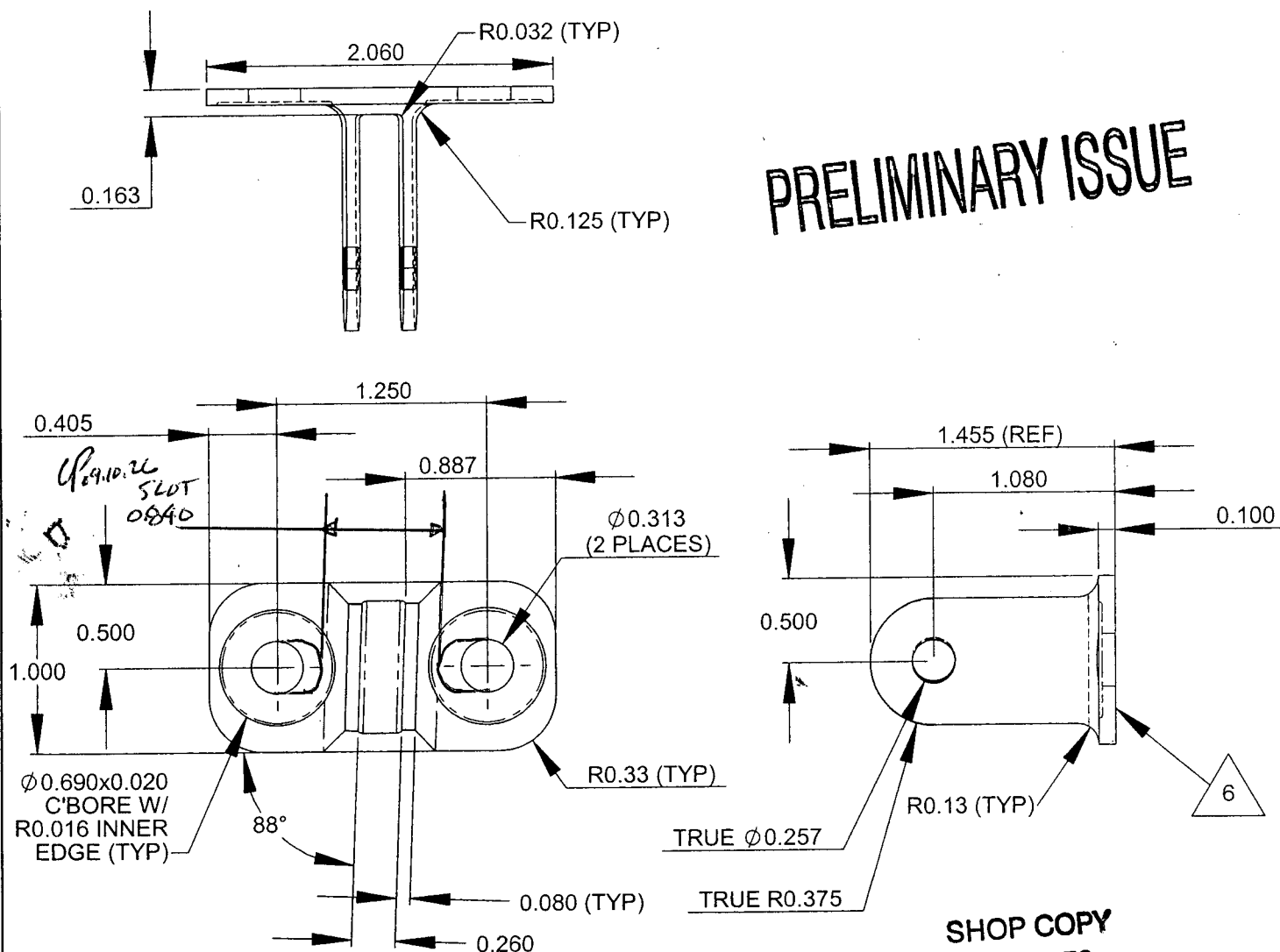
<b>Measured by:</b>	EC	<b>Audited by:</b>	EP	<b>Prototype Approval:</b>	✓ N/A
<b>Date:</b>	04.10.18	<b>Date:</b>	04.10.18	<b>Date:</b>	04.10.26 N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	04.10.04	New Issue	KJ/JLM	✓

**RELEASED**  
04.10.18



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3316	REV. A SHEET 1 OF 1
DATE 04.09.14		TITLE FITTING	SCALE 1:1
A	04.09.14	NEW ISSUE	



PRELIMINARY ISSUE

SHOP COPY  
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WORK ORDER  
NO. 21669

**D3316-1 FITTING (-2 FITTING OPPOSITE)**

- 1) MATERIAL: 17-4PH SS BAR (REF DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005" TO 0.015"
- 6) WRITE P/N AND B/N IN THIS AREA IN 0.125" HIGH TEXT AND USING A FINE POINT PERMANENT INK MARKER.

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury







Oct 08, 2004  
11:24 am

Work Order No : 0021669  
Project Name : D3316-2  
Project For : WK442  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3316-2  
Description : Fitting  
Manufactured : Yes  
Amount Req'd : *12*  
Amount Done : 0  
Start Date : 10-08-04  
Est Finish Date : 10-15-04  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
04.10.21	3	PART WILL NOT FIT AS DESIGNED PER D3316 REV. A MODIFY AS FOLLOWS  → ← 0.840	1 → D3116-1 1 → D3116-2	 04.10.25	2	 04.10.27	 04.10.27	
04.10.27		UPDATE DWG. THIS WILL BE A PERMANENT CHANGE				 04.10.27	 04.10.27	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date &amp; Initial all entries

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